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December 1999

Processes

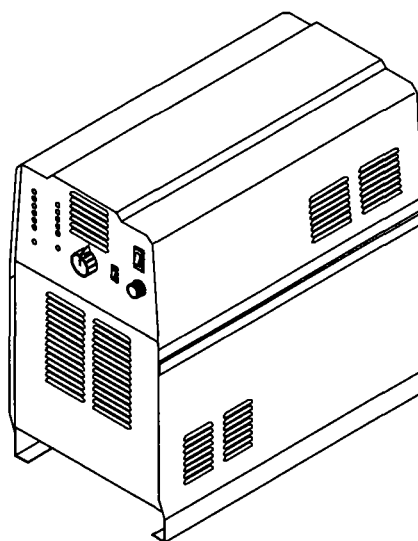
Induction Heating

Description



Induction Heating Power Source

Intellifire 250



OWNER'S MANUAL

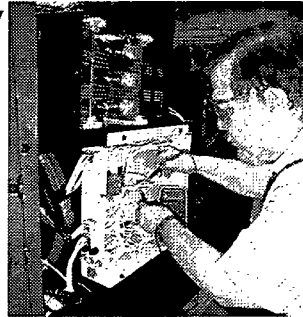


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www.MillerWelds.com

From Miller to You

Thank you and congratulations on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.



Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

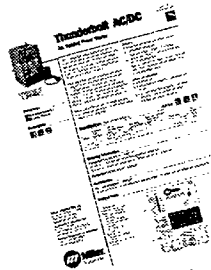
This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite. We've

made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide which exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001 Quality System Standard.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual catalog sheets. To locate your nearest distributor call 1-800-4-A-Miller.



Working as hard as you do - every power source from Miller is backed by the most hassle-free warranty in the business.

Miller offers a Technical Manual which provides more detailed service and parts information for your unit. To obtain a Technical Manual, contact your local distributor. Your distributor can also supply you with Welding Process Manuals such as SMAW, GTAW, GMAW, and GMAW-P.



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SECTION 1 - SAFETY PRECAUTIONS - READ BEFORE USING

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1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ Marks a special safety message.

☞ Means "Note"; not safety related.



This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Induction Heating Hazards

▲ The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-4. Read and follow all Safety Standards.

▲ Only qualified persons should install, operate, maintain, and repair this unit.

▲ During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The power circuit and output bus bars or connections are electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Enclose any connecting bus bars and coolant fittings to prevent unintentional contact.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Disconnect input power before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Use only nonconductive coolant hoses with a minimum length of 18 inches (457 mm) to provide isolation.
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground - check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first - double-check connections.
- Frequently inspect input power cord for damage or bare wiring - replace cord immediately if damaged - bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- Do not touch power circuit if you are in contact with the work, ground, or another power circuit from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.

SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any internal parts.



INDUCTION HEATING can cause burns.

- Hot parts and equipment can injure.
- Do not touch or handle induction head/coil during operation.
- Do not touch hot parts bare-handed.
- Allow cooling period before handling parts or equipment.
- Keep metal jewelry and other metal personal items away from head/coil during operation.



FIRE OR EXPLOSION hazard.

- Do not overheat parts and adhesive.
- Watch for fire; keep extinguisher nearby.
- Keep flammables away from work area.
- Do not locate unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not operate unit in explosive atmosphere.

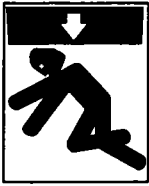


FUMES AND GASES can be hazardous.

Induction Heating of certain materials, adhesives, and fluxes can produce fumes and gases. Breathing these fumes and gases can be hazardous to your health.

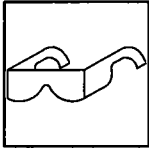
- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust to remove fumes and gases.
- If ventilation is poor, use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for adhesives, fluxes, metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watchperson nearby. Fumes and gases from heating can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not heat in locations near degreasing, cleaning, or spraying operations. The heat can react with vapors to form highly toxic and irritating gases.
- Do not overheat coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the heated area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if overheated. See coating MSDS for temperature information.

1-3. Additional Symbols for Installation, Operation, and Maintenance



FALLING UNIT can cause injury.

- Use handle and have person of adequate physical strength lift unit.
- Move unit with hand cart or similar device.
- For units without a handle, use equipment of adequate capacity to lift unit.
- When using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



FLYING METAL OR ADHESIVE can injure eyes.

- Wear approved safety glasses with side shields or wear face shield.



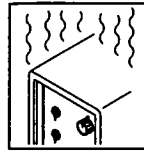
MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.



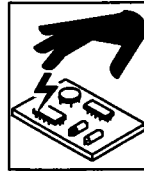
MAGNETIC FIELDS can affect pacemakers.

- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near induction heating operations.



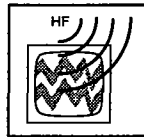
OVERUSE can cause OVERHEATING

- Allow cooling period.
- Reduce output or reduce duty cycle before starting to heat again.
- Follow rated duty cycle.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified person familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut.

1-4. Principal Safety Standards

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Canadian Electrical Code Part 1, CSA Standard C22.1, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices For Occupation And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

1-5. EMF Information

Considerations About Induction Heating And The Effects Of Low Frequency Electric And Magnetic Fields

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, *Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper*, OTA-BP-E-53 (Washington, DC: U.S. Government Printing Office, May 1989): "... there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields can interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about

questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures:

1. Arrange output cable to one side and away from the operator.
2. Do not coil or drape output cable around the body.
3. Keep power source and cable as far away from the operator as practical.

About Pacemakers:

The above procedures are also recommended for pacemaker wearers. Consult your doctor for complete information.

SECTION 1 - MESURES DE SECURITE POUR LE CHAUFFAGE PAR INDUCTION

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AVERTISSEMENT

LE CHAUFFAGE PAR INDUCTION peut être dangereux.

PRENDRE LES MESURES NECESSAIRES POUR EVITER LES RISQUES DE BLESSURES GRAVES, VOIRE MORTELLES. TENIR LES ENFANTS A DISTANCE. LES PORTEURS D'UN STIMULATEUR CARDIAQUE DOIVENT PREALABLEMENT CONSULTER LEUR MEDECIN.

Pendant les opérations de chauffage, comme dans la plupart des activités, l'opérateur s'expose à certains dangers. Le chauffage n'est pas dangereux à condition de prendre certaines mesures. Les consignes de sécurité indiquées ci-après ne sont qu'un résumé des informations plus détaillées se trouvant dans les normes de sécurité énumérées à la page suivante. Lire et respecter toutes les normes de sécurité.

LES OPERATIONS D'INSTALLATION, DE FONCTIONNEMENT, DE MAINTENANCE ET DE REPARATION NE DOIVENT ETRE CONFIEES QU'A DU PERSONNEL QUALIFIE.



Danger de mort PAR ELECTROCUTION.

Le contact de composants électriques peut provoquer des accidents mortels ou des brûlures graves. Le circuit de puissance et les connexions de sortie sont sous tension lorsqu'on active la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur marche. Des équipements installés ou reliés à la borne de terre de manière incorrecte sont dangereux.

1. Ne pas toucher des composants électriques sous tension.
2. Envelopper les connexions et raccords de refroidissement pour éviter tout contact accidentel.
3. Porter des gants d'isolation secs, sans trous, et une protection corporelle.
4. Isoler-vous de la pièce et du sol avec des tapis ou des couvertures d'isolation suffisamment grands pour prévenir tout contact physique avec la pièce ou la terre.
5. Déconnecter l'alimentation avant d'installer l'appareil ou d'en effectuer l'entretien. Verrouiller ou étiqueter la sortie d'alimentation selon la norme OSHA 29 CFR 1910.147 (se reporter aux Principales normes de sécurité).
6. Utiliser seulement des tuyaux non conducteurs avec une longueur minimale de 460 mm pour assurer l'isolement.
7. Installer et mettre cet équipement correctement à la terre conformément au manuel utilisateur et aux codes nationaux, gouvernementaux et locaux.
8. Vérifier souvent la terre de l'alimentation - contrôler et s'assurer que le conducteur de terre du câble d'alimentation est correctement relié à la borne de terre dans le boîtier de déconnexion ou que le connecteur est branché à une sortie de boîtier correctement mise à la terre.
9. En réalisant des connexions d'entrée brancher d'abord le conducteur de terre approprié - contrôler deux fois les connexions.
10. Vérifier souvent le bon état du câble d'alimentation ou l'isolation des fils - remplacer le câble immédiatement s'il est endommagé - des fils dénudés peuvent provoquer des accidents mortels.
11. Arrêter tous les équipements lorsqu'ils ne sont pas utilisés.
12. Ne pas utiliser des câbles usés, endommagés, sous dimensionnés ou mal épissés.
13. Ne pas porter les câbles autour de votre corps.
14. Ne pas toucher le circuit électrique si vous êtes en contact avec la pièce, la terre ou le circuit électrique d'une autre machine.
15. Utiliser seulement des équipements bien entretenus. Réparer ou remplacer immédiatement des composants endommagés. Effectuer des travaux d'entretien sur l'appareil selon le manuel.
16. Porter un harnais de sécurité pour effectuer des travaux au-dessus du sol.
17. Maintenir solidement en place tous les panneaux et couvercles.



LE CHAUFFAGE PAR INDUCTION peut provoquer des blessures ou des brûlures au contact de PIECES CHAUDES OU DE L'EQUIPEMENT.

1. Ne pas toucher ou manipuler la tête/l'enroulement à induction pendant le fonctionnement.
2. Tenir les bijoux et autres objets personnels en métal éloignés de la tête/de l'enroulement pendant le fonctionnement.
3. Laisser refroidir les composants ou équipements avant de les manipuler.



LE CHAUFFAGE PAR INDUCTION peut provoquer un incendie.

1. Ne pas surchauffer les composants ni les adhésifs.
2. Attention aux risques d'incendie: tenir un extincteur à proximité.
3. Stocker des produits inflammables hors de la zone de travail.

La mise en place de l'appareil sur, au-dessus ou à proximité de surfaces inflammables peut être source d'INCENDIES OU d'EXPLOSION.

1. Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
2. Ne pas installer l'appareil à proximité de produits inflammables.
3. Ne pas faire fonctionner l'appareil en atmosphère explosive.



DES FUMÉES ET DES GAZ peuvent être dangereux pour votre santé.

Le chauffage à induction génère des fumées et des gaz. Leur inhalation peut être dangereuse pour votre santé.

1. Eloigner la tête des fumées. Ne pas respirer les fumées.
2. A l'intérieur, ventiler la zone et/ou utiliser un extracteur pour l'évacuation des fumées et des gaz.
3. Si la ventilation est insuffisante, utiliser un respirateur à alimentation d'air homologué.
4. Lire les spécifications de sécurité des matériaux (MSDSs) et les instructions du fabricant concernant les adhésifs, les métaux, les consommables, les revêtements, les nettoyants et les dégraisseurs.

5. Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz provenant du chauffage peuvent déplacer l'air, abaisser le niveau d'oxygène, et provoquer des lésions ou des accidents mortels. S'assurer que l'air ambiant ne présente aucun danger.
6. Ne pas chauffer dans des endroits se trouvant à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur peut réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
7. Ne pas chauffer des métaux munis d'un revêtement tels que l'acier galvanisé, plaqué au plomb ou au cadmium, à moins que le revêtement ne soit enlevé de la zone chauffée, que la zone soit bien ventilée et, si nécessaire, en portant un respirateur. Les revêtements et tous les métaux contenant ces éléments peuvent dégager des fumées toxiques s'ils sont chauffés.

1-1. Dangers supplémentaires de mise en route, de fonctionnement et d'entretien

	LA CHUTE DE MATERIEL peut provoquer des blessures personnelles graves et endommager les équipements.		UNE UTILISATION INTENSIVE peut provoquer un SURCHAUFFEMENT DU MATERIEL.
	<ol style="list-style-type: none"> 1. Utiliser la poignée et demander à une personne ayant la force physique nécessaire pour soulever l'appareil. 2. Déplacer l'appareil à l'aide d'un charriot ou d'un engin similaire. 3. Pour les appareils sans poignée utiliser un équipement d'une capacité appropriée pour soulever l'appareil. 4. En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil. 		L'ELECTRICITE STATIQUE peut endommager les composants des tableaux électriques.
	LA PROJECTION DE PIECES DE METAL ou DE COLLE peut provoquer des blessures aux yeux.		Il subsiste DU COURANT CONTINU IMPORTANT après la mise hors tension de l'alimentation électrique.
	DES ORGANES MOBILES peuvent provoquer des blessures.		LE RAYONNEMENT HAUTE FREQUENCE peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
	DES CHAMPS MAGNETIQUES CREEES PAR DES COURANTS ELEVES peuvent affecter le fonctionnement du stimulateur cardiaque.		<ul style="list-style-type: none"> • Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation. • L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation. • Si le FCC signale des interférences, arrêter immédiatement l'appareil. • Effectuer régulièrement le contrôle et l'entretien de l'installation. • Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence.
	<ol style="list-style-type: none"> 1. Porteurs de stimulateur cardiaque, restez à distance. 2. Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de chauffage à induction. 		

1-2. Informations concernant les champs électro-magnétiques (Information EMF)

Considérations relatives au chauffage à induction et aux effets des champs électriques et magnétiques basse fréquence.

Le texte suivant est extrait des conclusions générales Département du Congrès U.S., Office of Technology Assessment, *Effets biologiques des champs magnétiques et électriques basse fréquence - Background Paper*, OTA-BP-E-53 (Washington, DC: U.S. Government Printing Office, May 1989): "... on dispose maintenant d'importantes découvertes scientifiques reposant sur des expériences effectuées dans le domaine cellulaire et des études réalisées sur des animaux et des personnes qui démontrent clairement que des champs magnétiques basse fréquence peuvent avoir une interaction et produire des changements dans les systèmes biologiques. Alors que la plus grande partie de cet ouvrage est d'une très grande qualité, les résultats sont complexes. La compréhension scientifique courante ne nous permet pas encore d'interpréter la preuve fournie dans un seul ouvrage cohérent. Il est encore plus frustrant de ne pas pouvoir tirer des conclusions définitives en ce qui concerne les problèmes de risque possible ou de proposer des recommandations scientifiques claires

pour des stratégies à suivre en vue de minimiser ou de prévenir des risques potentiels."

Pour réduire les champs magnétiques sur le poste de travail, appliquer les procédures suivantes :

4. Disposer le câble de sortie d'un côté à distance de l'opérateur
5. Ne pas enrouler ou draper le câble électrique autour du corps.
6. Placer la source de courant et le câble le plus loin possible de l'opérateur.

En ce qui concerne les stimulateurs cardiaques

Les procédures ci-dessus concernent également les porteurs de stimulateur cardiaque. Consulter votre médecin pour un complément d'information.

PRINCIPALES NORMES DE SÉCURITÉ

Normes de sécurité et de santé, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Code électrique national, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Code électrique du Canada, partie 1, CSA Standard C22.1, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices For Occupation And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

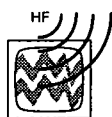
SECTION 2 - INSTALLATION

2-1. Specifications

Output Frequency	Rated Output	Required Reflective Inductance	Amperes Input at Rated Load Output 50 or 60 Hz, Three-Phase			Overall Dimensions	Weight
			460 V	KVA	KW		
10 To 50 kHz	25 kW At 100% Duty Cycle - Max 750 A (RMS), 700 V (RMS)	2.5 To 50 μ h	39 0.29*	30.8	27.19	Length: 31 in (787 mm) Width: 16 in (406 mm) Height: 27 in (686 mm)	120 lb (54 kg)

*While idling

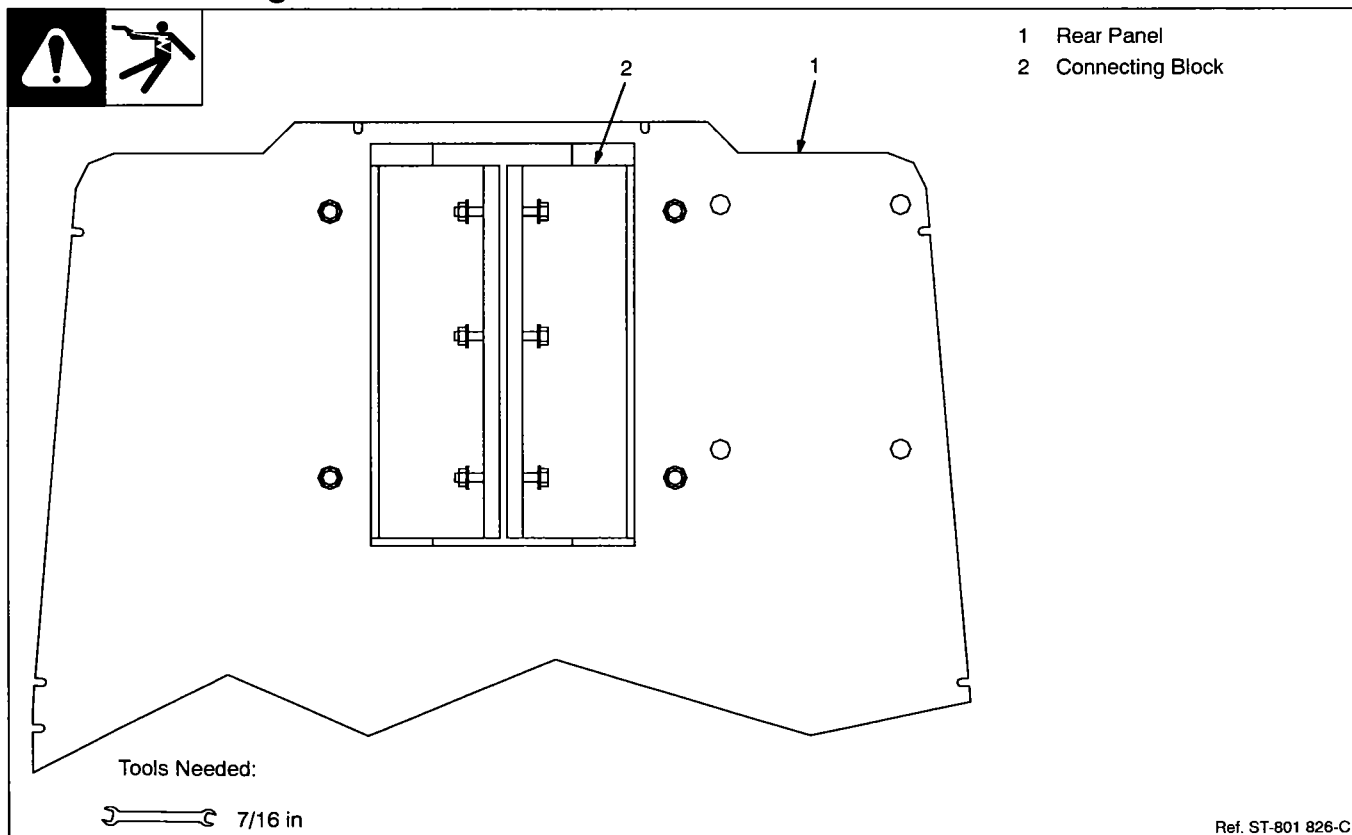
WARNING



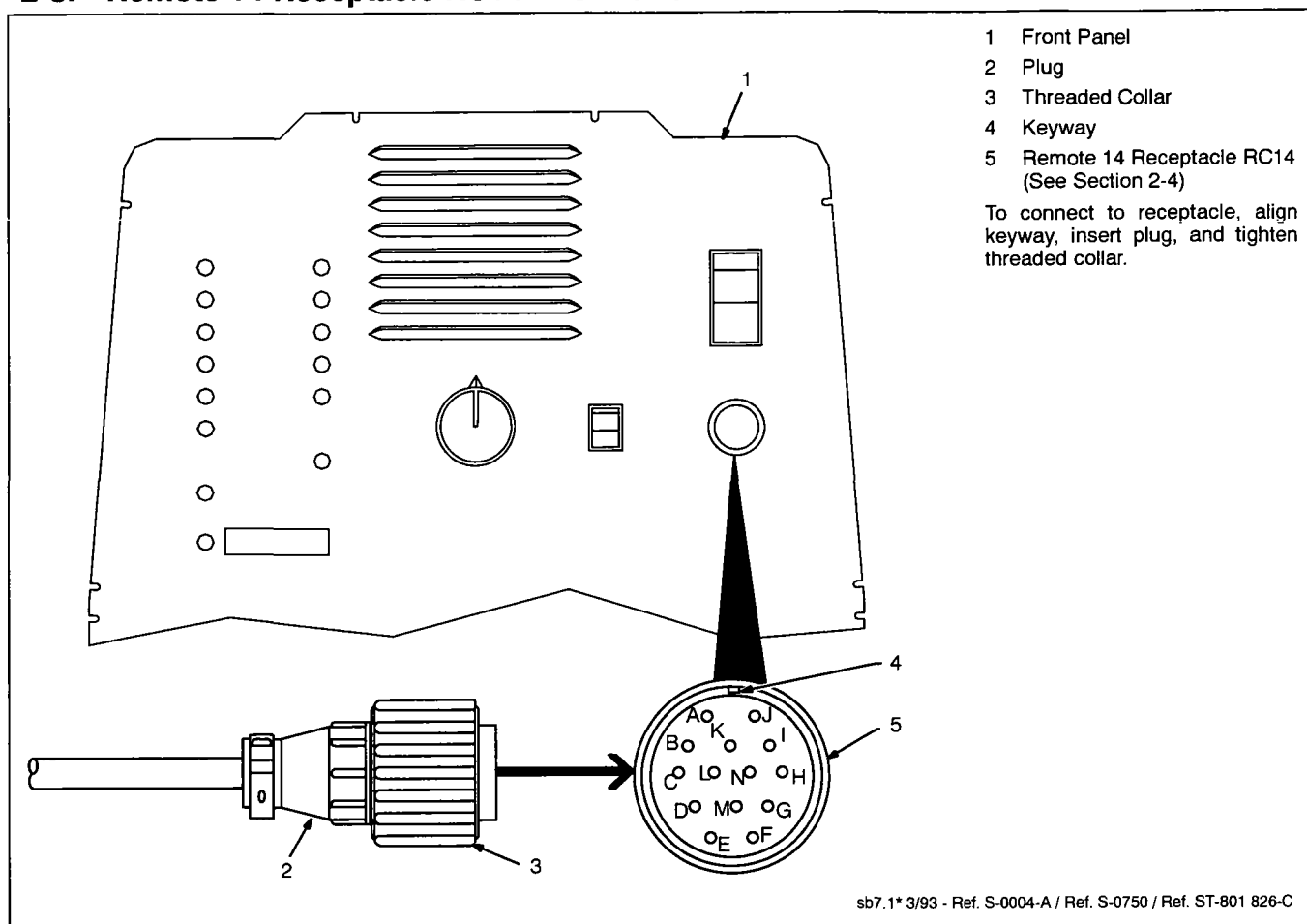
HIGH-FREQUENCY RADIATION can interfere with radio navigation, safety services, computers, and communications equipment.

- Have only qualified person familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut.


2-2. Connecting Head/Coil to Power Source



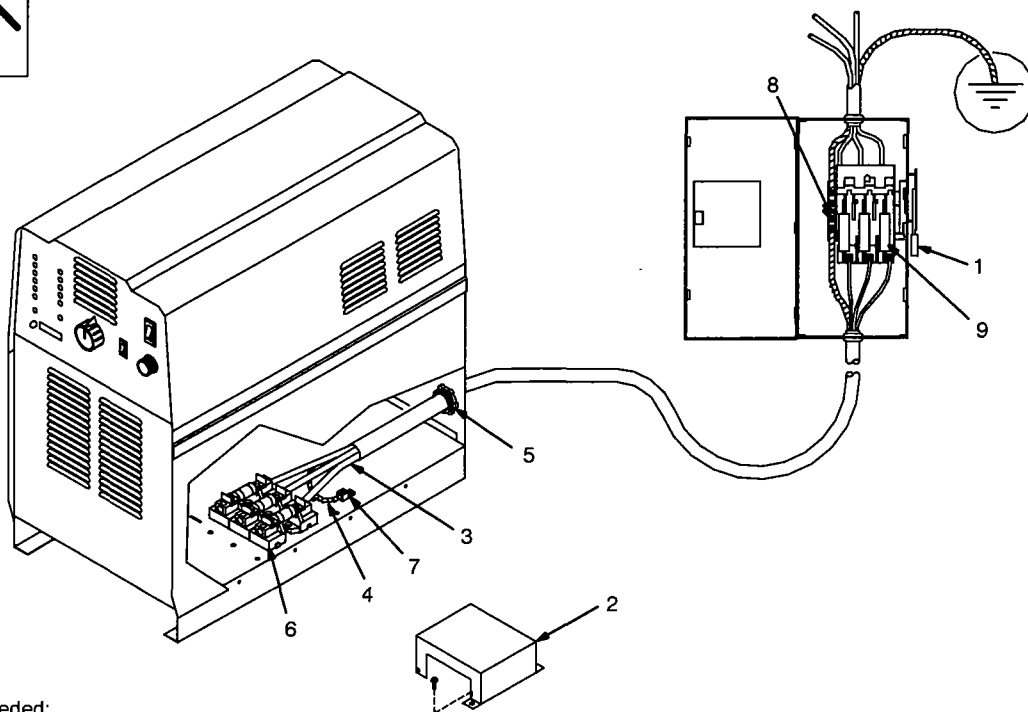
2-3. Remote 14 Receptacle RC14 Information and Connections



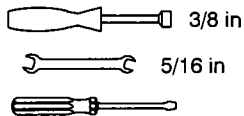
2-4. Remote 14 Socket Information

 REMOTE 14	Socket	Socket Information
Remote Contactor	A	+24 volts dc.
	B	Contact closure to A completes 24 volts dc contactor control circuit.
Remote Output Control	C	Command reference; +10 volts dc.
	D	Control circuit common.
	E	Input command signal (potentiometer wiper or 0 to +10 volts dc).
	G	Not used.
Power Source Limit	F, J	Absence of internal contact closure between F and J signals power source failure to remote control device.
Remote Metering	H	Coil loss compensation value.
	I	Actual frequency output signal (1 volt/10 kHz).
	L	Average power output signal (1 volt/5 kW).
	M	Voltage output signal RMS (1 volt/100 volts).
	N	Current output signal RMS (1 volt/100 amperes).
	K	Chassis common.

2-5. Connecting Input Power



Tools Needed:



Ref. ST-801 825-C

Have only qualified persons make this installation.

Remove wrapper.

1 Line Disconnect Device Of Proper Rating

Obtain and install line disconnect device.

2 Fuse Block Cover

Remove fuse block cover.

3 Input Conductors

4 Grounding Conductor

Select size and length using Section 2-6. Conductor rating must comply with national,

state, and local electrical codes. Route input power cord through strain relief on rear panel to fuse block.

5 Strain Relief Connector

Insert conductors through strain relief.

6 Input Fuse Block

7 Power Source Ground Terminal

Connect grounding conductor to ground terminal first. Then connect input conductors to fuse block.

8 Disconnect Device Ground Terminal

Install and connect grounding conductor and input conductors in conduit or equivalent to deenergized line disconnect device.

Connect grounding conductor first, then line input conductors.

Be sure grounding conductor goes to an earth ground.

Reinstall fuse block cover.

Tighten strain relief, and reinstall wrapper.

9 Overcurrent Protection

Select type and size using Section 2-6. Install into deenergized line disconnect device (fused disconnect switch shown).

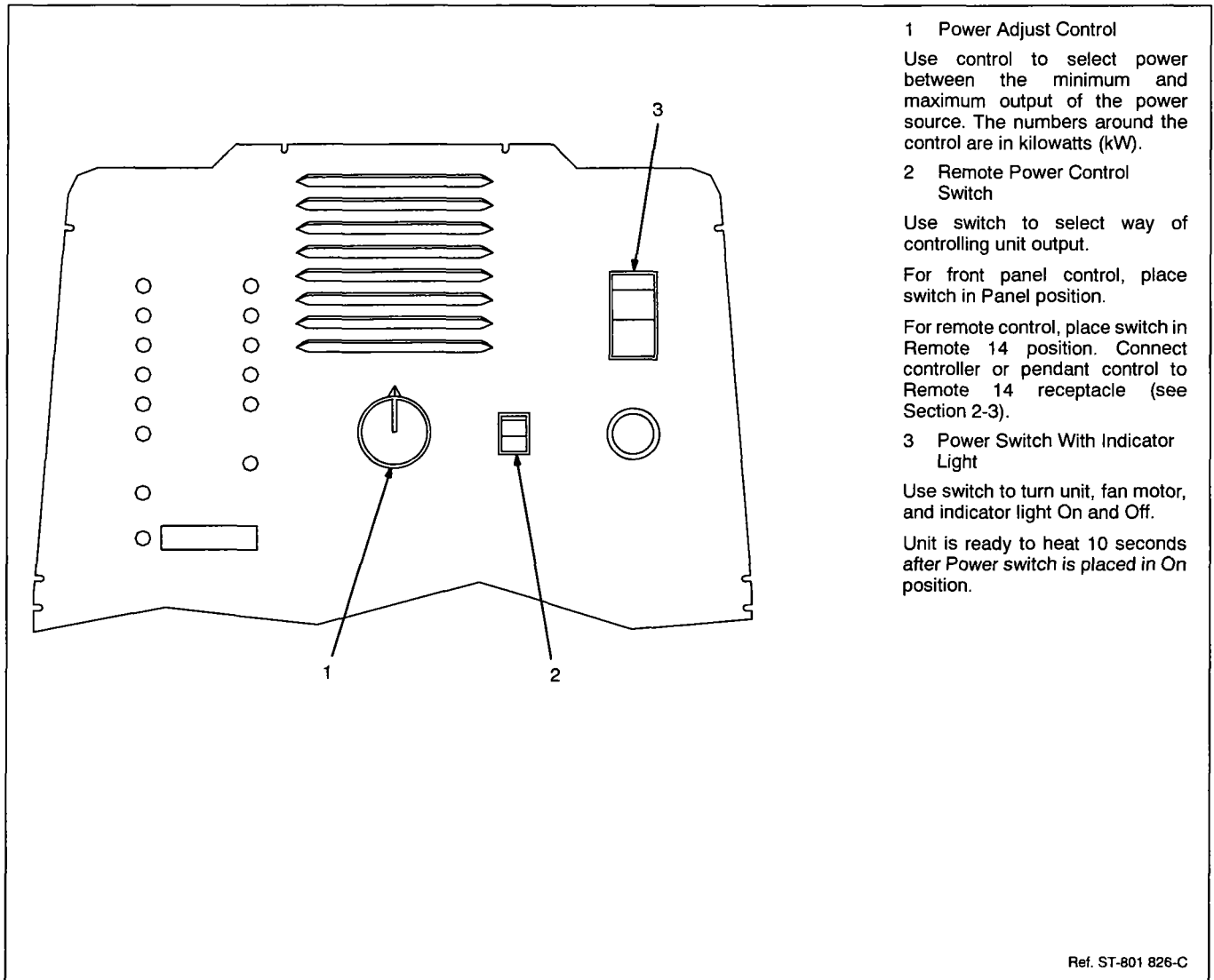
2-6. Electrical Service Guide

Input Voltage	460
Input Amperes At Rated Output	39
Max Recommended Standard Fuse Or Circuit Breaker Rating In Amperes	60
Min Input Conductor Size In AWG/Kcmil	8
Max Recommended Input Conductor Length In Feet (Meters)	248 (76)
Min Grounding Conductor Size In AWG/Kcmil	10
Reference: 1993 National Electrical Code (NEC).	

S-0092J

SECTION 3 - OPERATION

3-1. Controls



SECTION 4 - MAINTENANCE & TROUBLESHOOTING

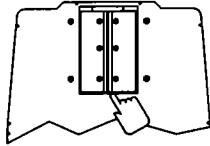
4-1. Routine Maintenance

▲ Disconnect power before maintaining.

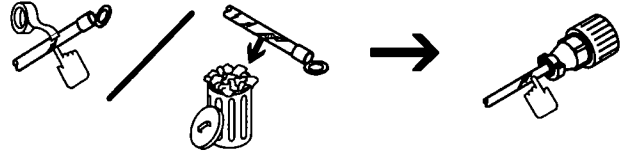
☞ Maintain more often during severe conditions.

3 Months

Clean and tighten output connections.

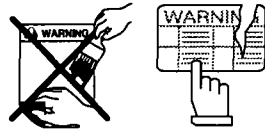


Repair or replace cracked cables and cords.

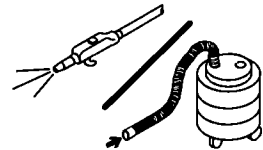


6 Months

Replace damaged or unreadable labels.



Blow out or vacuum inside.



4-2. Overheating

Thermostats TP1, TP2, and TP3 protect the unit from damage due to overheating. If one or more of the heat sinks get too hot, TP1, TP2, and/or TP3 opens and output stops. The fan keeps running to cool the heat sink(s). Wait several minutes before trying to heat.

4-3. Automatic Shutdown Protection

This unit automatically shuts down upon sensing certain fault conditions, such as an out-of-range frequency condition, short circuit load condition, or an open circuit (no load) condition. The unit also has automatic voltage limiting and power ratio limiting, which limits the output power based on improper load impedance.

4-4. Safety Interlock Switch

1 Rear Panel

2 Safety Interlock Switch

The safety interlock switch prevents the contactor from energizing with the wrapper off the unit.

Tools Needed:

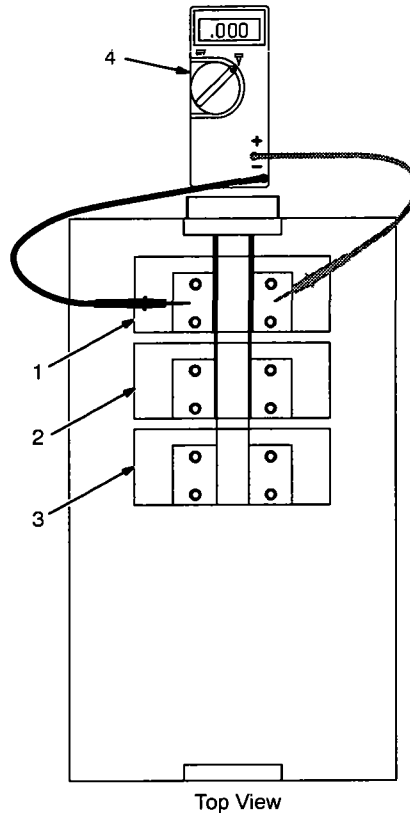
3/8 in

Ref. ST-801 826-C

4-5. Measuring Tuning Capacitor Voltage

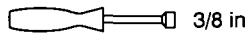


▲ Significant DC voltage can remain on capacitors after unit is Off. Always check ALL capacitors as shown to be sure they have discharged before working on unit.



Top View

Tools Needed:



3/8 in

Turn Off power source and disconnect input power.

Remove wrapper.

- 1 Tuning Capacitor C1
- 2 Tuning Capacitor C2
- 3 Tuning Capacitor C3
- 4 Voltmeter

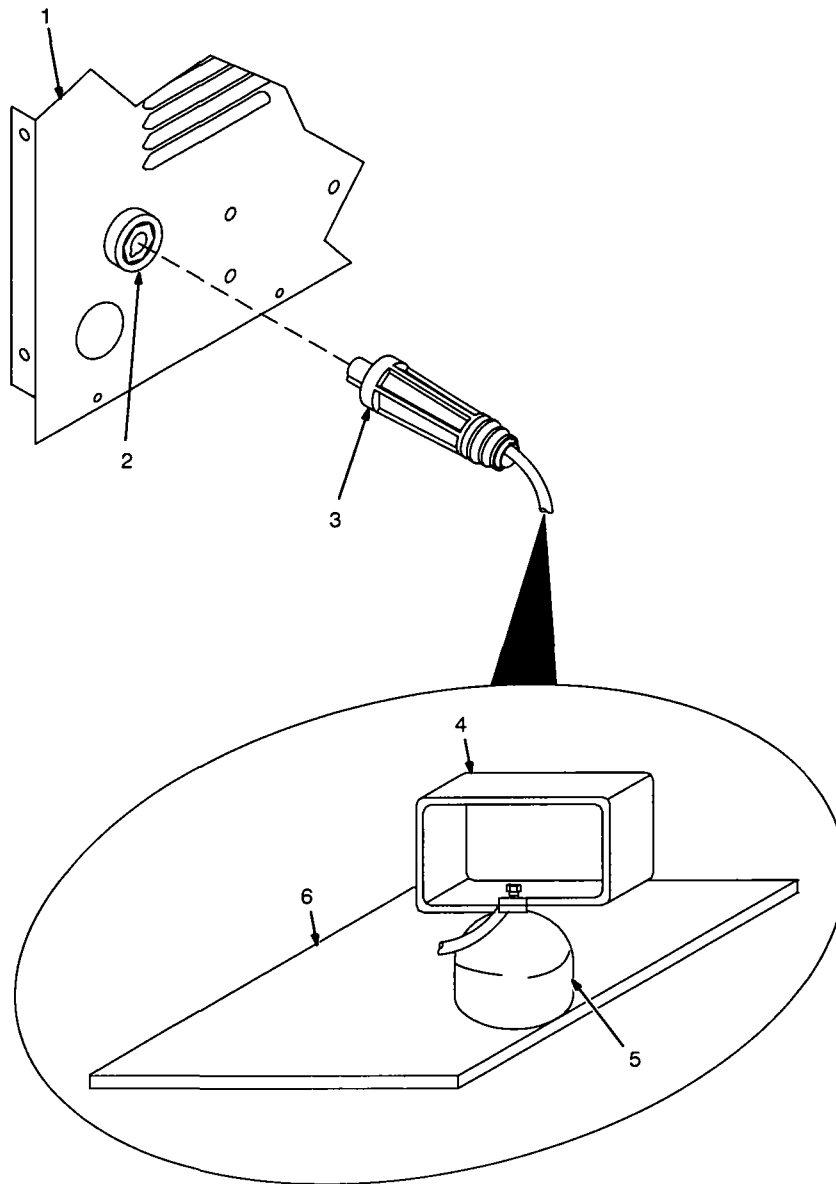
Check tuning capacitors.

Measure the dc voltage across the positive (+) and negative (-) terminals every 30 seconds until voltage is near 0 (zero) volts.

Proceed with job inside unit. Reinstall wrapper when finished.

Ref. ST-801 826-A

4-6. Optional Ground Fault Protection



Ground fault protection circuitry automatically shuts down power source output if a potentially hazardous condition exists at the heating device connected to the power source (e.g. insulation has broken down on a heating blanket causing the conductor to come into contact with the workpiece or a heating coil touches the workpiece causing a short in the output circuit).

The ground lead provided with this option must be connected between the workpiece and power source to provide proper ground fault protection from a short in the output circuit.

- 1 Power Source
- 2 Receptacle
- 3 Plug

To connect plug, align key with keyway, insert end into receptacle, and rotate plug until tight.

- 4 Handle
- 5 Magnet
- 6 Workpiece

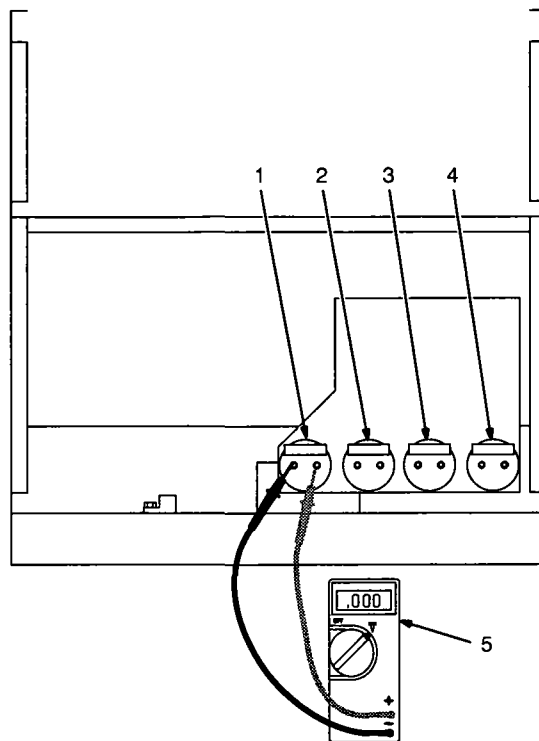
Use handle to place magnet on the workpiece.

Ref. ST-801 826-C / Ref. 801 828-C

4-7. Measuring Input Capacitor Voltage



▲ Significant DC voltage can remain on capacitors after unit is Off. Always check ALL capacitors as shown to be sure they have discharged before working on unit.



Tools Needed:



3/8 in

Turn Off power source and disconnect input power.

Remove wrapper.

- 1 Input Capacitor C2
- 2 Input Capacitor C1
- 3 Input Capacitor C4
- 4 Input Capacitor C3
- 5 Voltmeter

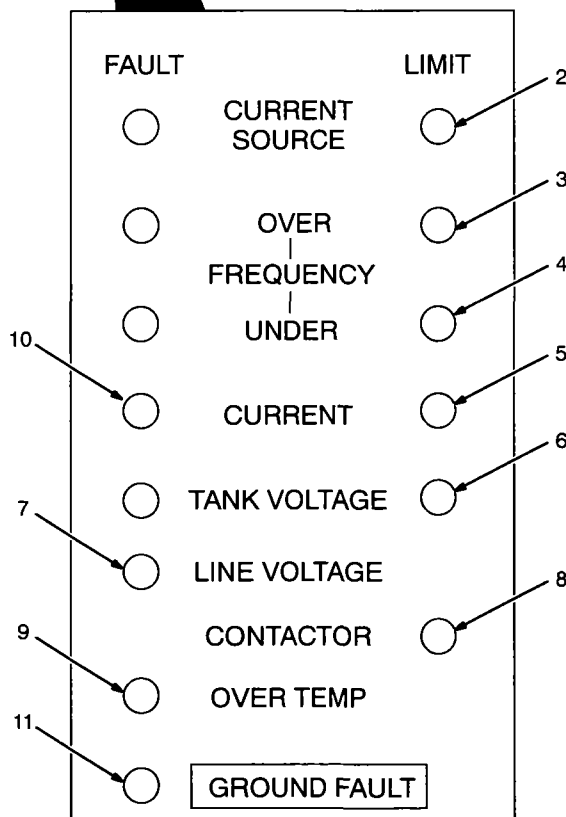
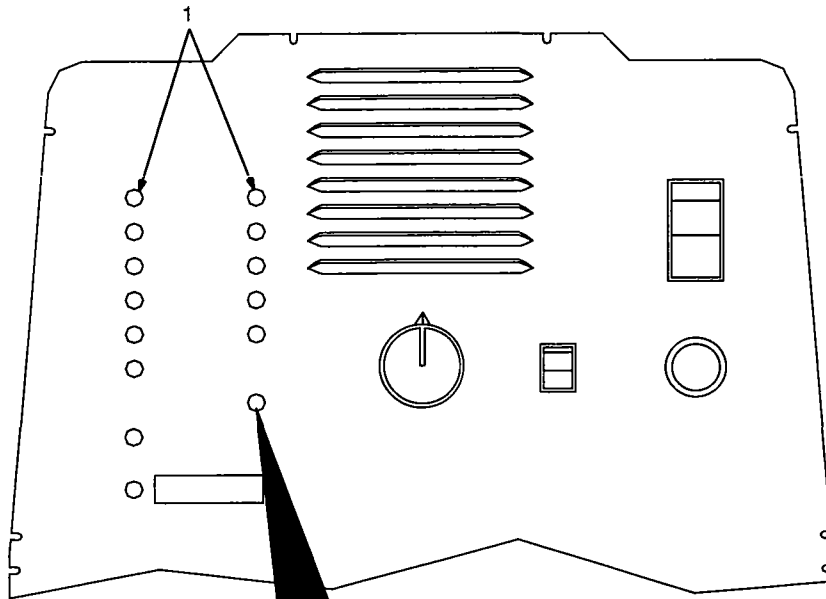
Check input capacitors.

Measure the dc voltage across the positive (+) and negative (-) terminals every 30 seconds until voltage is near 0 (zero) volts.

Proceed with job inside unit.
Reinstall wrapper when finished.

Ref. ST-801 826-A

4-8. Diagnostic LED's



1 Diagnostic LED's

Use diagnostic LED's to determine operating condition of power source.

2 Current Source

Limit: 110 A

Fault: 115 A

3 Over Frequency

Limit: 50 kHz

Fault: 55 kHz

4 Under Frequency

Limit: 10 kHz

Fault: 5 kHz

5 Current

Reactive Limit: 700 A

6 Tank Voltage

Limit: 670 V

Fault: 1100 V Peak

7 Line Voltage

Fault: $\pm 20\%$

8 Contactor

Lights when contactor is energized.

9 Over Temp

Lights when contactor is energized and over temperature condition is present. Also indicates top cover is removed from unit.

10 Tank Current

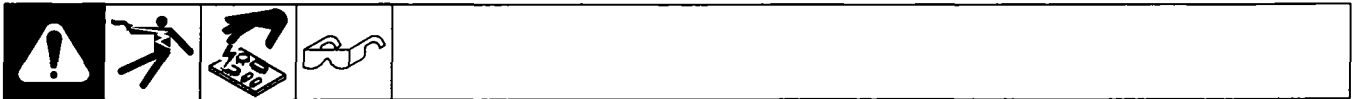
Fault Value Preset At Factory

11 Ground Fault (Optional)

Lights when the ground fault circuitry detects a short in the output circuit between the workpiece and power source.

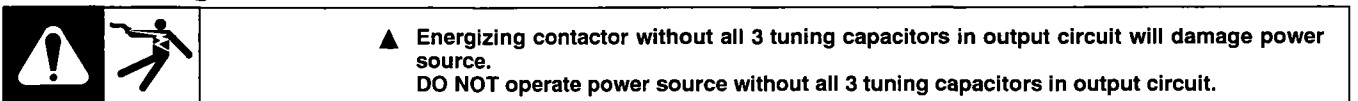
Ref. ST-801 826-B

4-9. Troubleshooting



Trouble	Remedy
No heat output.	Replace building line fuse or reset circuit breaker.
	Secure head/coil connecting plate to power source connecting block (see Section 2-2).
	Check and replace Power switch if necessary.
	Connect power source to proper input voltage or check for low line voltage.
No heat output; fan motor continues to run.	Safety interlock switch open. Reinstall wrapper (see Section 4-4).
	Thermostat(s) TP1, TP2, and/or TP3 open (overheating). Allow fan to run; the thermostat(s) will close when the unit has cooled (see Section 4-2).
Low heat output.	Check tuning of induction heating output system.

4-10. Tuning Chart



Voltage*	Current (Amperage)*	Frequency (KHz)	Corrective Action
High	Low	Low	Lower inductance or decrease matching transformer turns ratio
High	Low	High	Add capacitance
High	Low	Mid-Range	Decrease matching transformer turns ratio and add capacitance
Low	High	Low	Lower capacitance
Low	High	High	Increase matching transformer turns ratio, or lower capacitance and increase inductance
Low	High	Mid-Range	Increase matching transformer turns ratio and lower capacitance

*High voltage > 650 V rms; Low voltage < 400 V rms; Operating current range: 0 to 700 A rms

480 VOLTS ONLY

RED
WHT
BLK

F1
F2
F3

W1

SR1

PC3
CURRENT SOURCE INTERCONNECT
RC1/PLG23

L1 OUT
L1 IN

RC1-1
RC1-2
RC1-3
RC1-4
RC1-5
RC1-6
RC1-7
RC1-8
RC1-9
RC1-10
RC1-11
RC1-12

RC2-1
RC2-2
RC2-3
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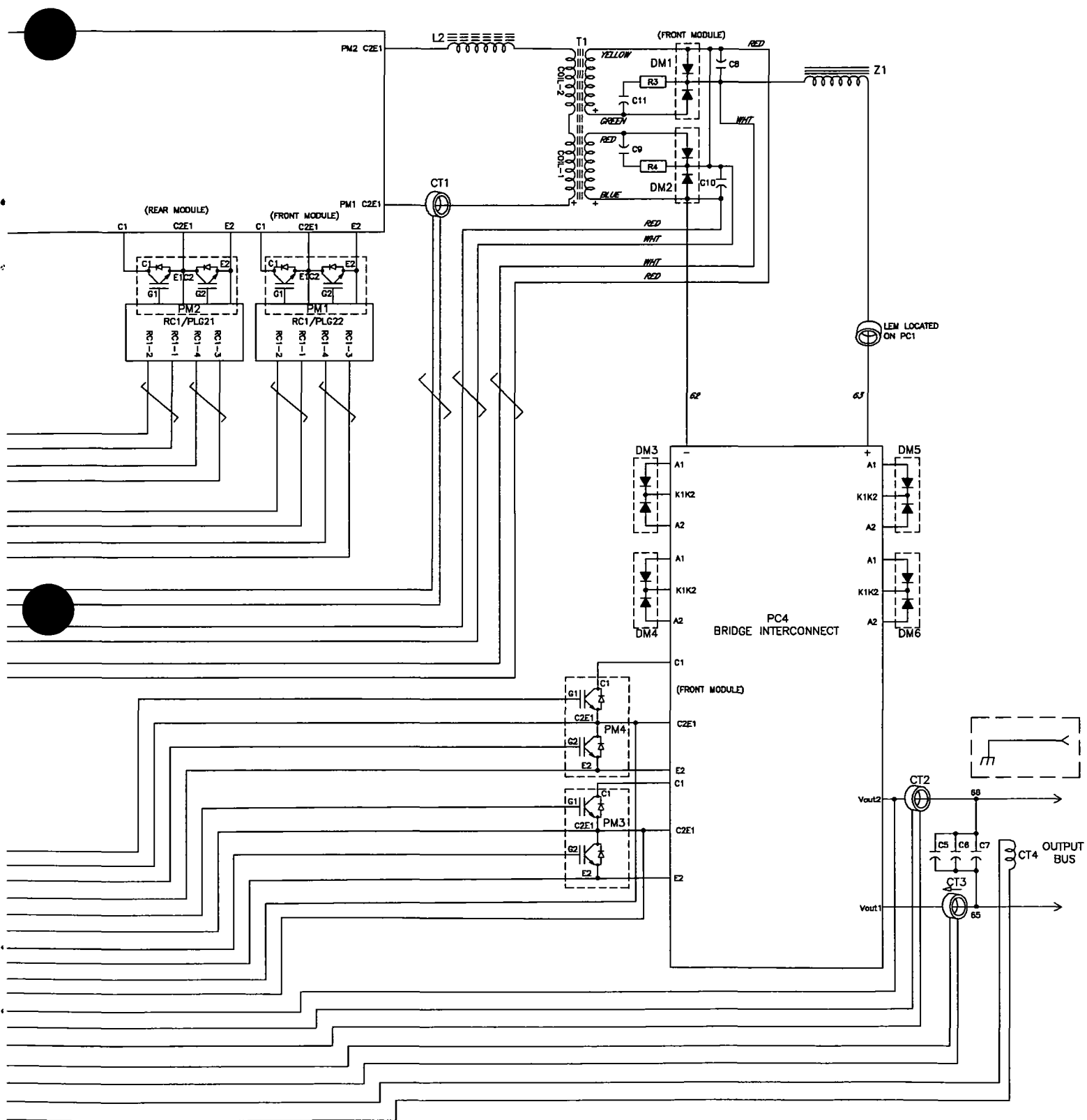
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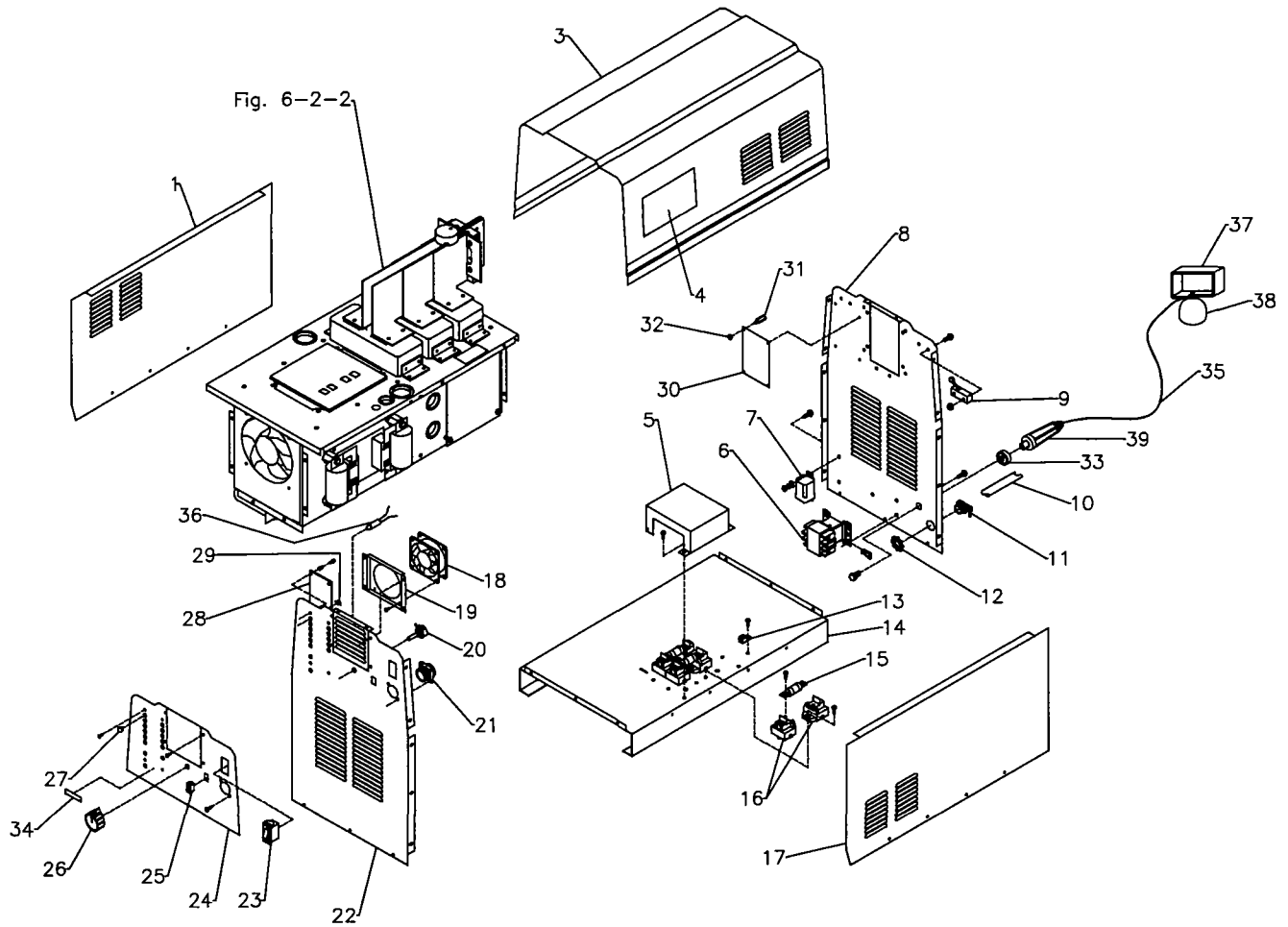
RC45-1
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RC4

OM-184 227 Page 16



SECTION 6 - PARTS LIST

 Hardware is common and not available unless listed.



ST-801 828-C

Figure 6-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 6-1. Main Assembly				
1		179 245	PANEL, side LH	1
2		Figure 6-2	CENTER BAFFLE ASSEMBLY	1
3		+179 246	WRAPPER	1
4		147 876	LABEL, warning general precautionary	2
5		195 830	COVER, fuse block	1
6	W1	124 886	CONTACTOR, def purpose 60A 3P 24V	1
7	CR1	000 174	RELAY, encl 24VAC 3PDT	1
8		179 231	PANEL, rear	1
9	S3	603 946	SWITCH, mag blwt lim 10A 125/250VDC	1
10		184 698	CABLE, pwr 12ft 8ga 4/c	1
11		186 441	BUSHING, strain relief	1
12		178 563	NUT, nylon	1
13		145 743	LUG, univ w/scr 600V	1
14		179 235	BASE	1
15	F1-3	*184 700	FUSE, semiconductor 50A 500V	1
16		184 696	BLOCK, fuse semiconductor modular	3
17		184 701	PANEL, side RH	1
18	FM2	184 702	MOTOR, fan 24VDC	1
	PLG26	135 635	CONNECTOR & SOCKETS	1
19		184 845	BRACKET, fan mtg small	1
20	R1	073 562	POTENTIOMETER, cp std slot 1/T 2W 10K ohm	1
21	RC14	143 976	RECEPTACLE w/SOCKETS	1
22		179 232	PANEL, front	1
23	S1	159 039	SWITCH, rocker SPDT 15A 125VAC	1
24			NAMEPLATE, (order by model and serial number)	1
25	S2	120 376	SWITCH, rocker SPDT 4A 250VAC	1
26		171 007	KNOB	1
27		159 036	LENS, LED clear	12
28	PC5	180 894	CIRCUIT CARD, diagnostic display	1
29		159 035	CLIP, retainer lens	12
30	PC6	196 854	CIRCUIT CARD ASSY, ground fault control	1
31		115 443	STAND-OFF, no 6-32 x .750 lg .250 hex	4
32		106 702	NUT, 006-32 .31 hex .20h stl pld	4
33		127 837	RECEPTACLE, tw lk insul fem	1
34		197 869	LABEL, ground fault	1
35		197 900	CABLE, work ground	1
36		197 854	LED, red 2.1 V 20 mA 45.0 mcd	1
37		198 035	HANDLE	1
38		197 931	MAGNET, permanent	1
39		127 836	PLUG, tw lk insul male	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

*Recommended Spare Parts.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 6-2. Center Baffle Assembly (Fig 6-1 Item 2)

1	PM1,2	188 190	IGBT w/CIRCUIT CARD ASSEMBLY	2
	PLG21,22	115 094	CONNECTOR & SOCKETS	2
2	TP1-3	006 334	THERMOSTAT,NC	1
3	SR1	173 630	DIODE, power module/scr 75A 1600V	1
4	PC3	181 170	CIRCUIT CARD, current source interconnecting	1
	PLG23	131 204	CONNECTOR & SOCKETS	1
5	F4,5	*012 658	FUSE, mintr gl slo-blo 2A 250V	2
6		098 376	HOLDER, fuse mintr	1
7	CT1	184 840	TRANSFORMER, current primary	1
	PLG13	135 635	CONNECTOR & SOCKETS	1
		155 748	BUS BAR, lem	1
8	PC1	178 064	CIRCUIT CARD, current source control	1
	PLG11,15	115 091	CONNECTOR & SOCKETS	1
	PLG12	115 092	CONNECTOR & SOCKETS	1
	PLG14	131 204	CONNECTOR & SOCKETS	1
	PLG16	131 056	CONNECTOR & SOCKETS	1
	PLG17	130 203	CONNECTOR & SOCKETS	1

Hardware is common and not available unless listed.

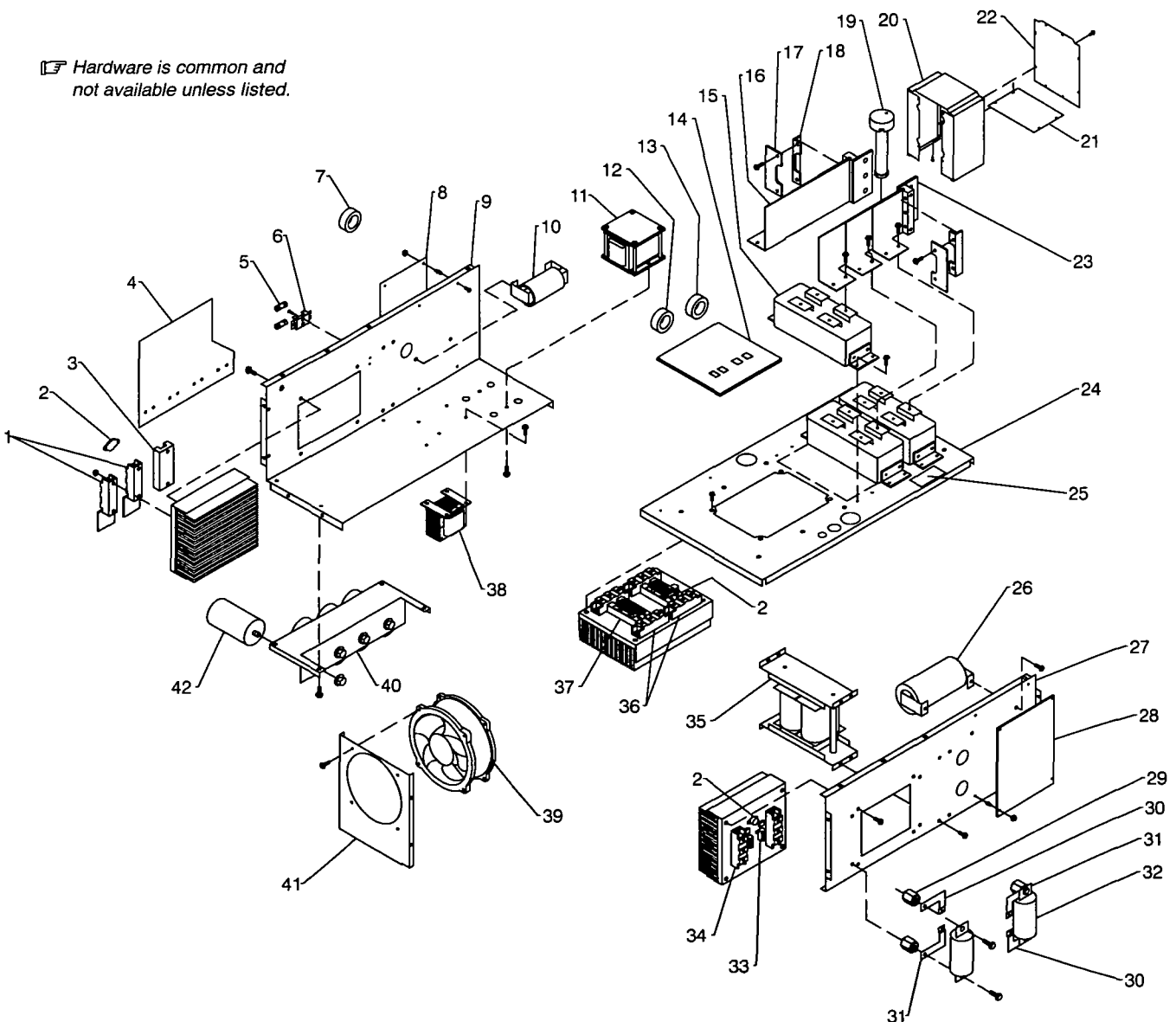


Figure 6-2. Center Baffle Assembly

ST-801 832-A

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 6-2. Center Baffle Assembly (Fig 6-1 Item 2)(Continued)				
9		179 233	WINDTUNNEL LH	1
10	L1	180 114	INDUCTOR, input	1
11	L2	182 563	INDUCTOR, series	1
12	CT2	184 842	TRANSFORMER, current bridge	1
13	CT3	184 841	TRANSFORMER, current power feedback	1
14	PC4	181 175	CIRCUIT CARD, bridge interconnecting	1
15	C5-7	179 220	CAPACITOR, polyp met film 1.5uf 1000VDC	3
16		179 239	BUS BAR, laminated output LH	1
17		186 523	STRIP, mtg output	2
18		192 515	BRACKET, mtg output block	2
19	CT4	185 935	SENSOR, tank current	1
20		196 245	ENCLOSURE, output	1
21		196 247	TOPPLATE, output enclosure	1
22		196 246	ENDPLATE, output enclosure	1
23		179 238	BUS BAR, laminated output RH	1
24		+179 236	MIDPLANE	1
25		126 026	LABEL, warning electric shock	2
26	Z1	180 115	STABILIZER	1
27		179 234	WINDTUNNEL RH	1
28	PC2	177 753	CIRCUIT CARD, bridge control (used with 903 469-01-2)	1
28	PC2	196 541	CIRCUIT CARD, bridge control (used with 903 469)	1
	PLG1	131 052	CONNECTOR & SOCKETS	1
	PLG2	130 203	CONNECTOR & SOCKETS	1
	PLG3	115 091	CONNECTOR & SOCKETS	1
	PLG4	131 056	CONNECTOR & SOCKETS	1
	PLG5	131 204	CONNECTOR & SOCKETS	1
	PLG6	115 092	CONNECTOR & SOCKETS	1
	PLG7	115 093	CONNECTOR & SOCKETS	1
29		025 248	STAND-OFF, insul .250-20 x 1.250	4
30		179 875	BUS BAR, diode RH	2
31		179 876	BUS BAR, diode LH	2
32	C8,10	170 867	CAPACITOR, polyp film 1.5uf 1000VDC	2
33	C9R4/C11R3	180 711	SNUBBER	2
34	DM1,2	179 869	DIODE, ultra fast recovery 100A 1200V	2
35	T1	182 564	TRANSFORMER, HF	1
36	DM3-6	179 869	DIODE, ultra fast recovery 100A 1200V	4
37	PM3,4	176 421	TRANSISTOR, IGBT module 150A 1200V	2
38	T2	179 870	TRANSFORMER, control	1
	PLG50	131 055	CONNECTOR & SOCKETS	1
39	FM1	182 575	MOTOR, fan 48VDC	1
	PLG25	135 635	CONNECTOR & SOCKETS	1
40		179 872	BRACKET, mtg capacitor	1
41		184 844	BRACKET, fan mtg	1
42	C1-4	174 980	CAPACITOR, elect 2700ufd 420VDC	4
	PLG8	115 092	CONNECTOR & SOCKETS	1
	RC8	135 409	CONNECTOR & PINS	1
	PLG160	131 052	CONNECTOR & SOCKETS	1
	RC160	188 352	CONNECTOR & PINS	1

*Recommended Spare Parts.

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Notes



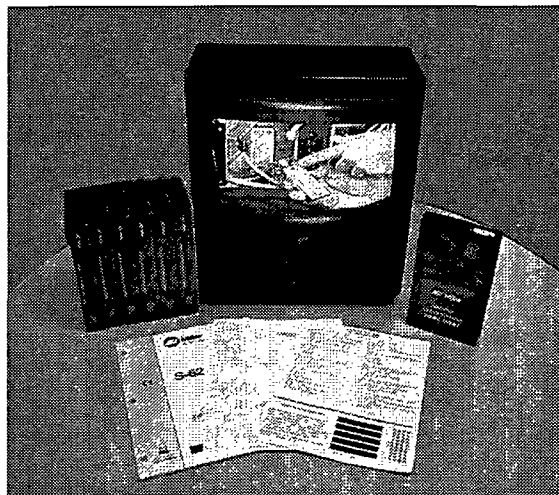
SERVICE VIDEOS

SERVICE TRAINING FROM MILLER ELECTRIC -

These Service Videos will help you learn about maintenance, troubleshooting, and servicing specific Miller equipment.

Also, if you are a Miller Certified Service Technician, these videos can help you recertify. Passing the included test will earn five points towards the forty points needed.

You will find each of these professionally produced videos to be very informative and a valuable part of your Service Video Library.



ORDERING INFORMATION

<input type="checkbox"/> XMT 304 Video Kit (#197 018) 324-1035 \$86.00	<input type="checkbox"/> Feeder Series Package (2 videos - S-62& S-54 & 60M) (#197 006) 324-1009 \$126.00
<input type="checkbox"/> Additional XMT 304 Test Sheet (#197 019) 324-1008 \$3.00	<input type="checkbox"/> Bobcat 225 NT Video Kit (#197 007) 324-1014 \$86.00
<input type="checkbox"/> S-62 & S-64 Series Video Kit (#197 012) 324-1030 \$86.00	<input type="checkbox"/> Additional Bobcat 225 NT Test Sheet (#197 009) 324-1018 \$3.00
<input type="checkbox"/> Additional S-62 & S-64 Test Sheet (#197 014) 324-1016 \$3.00	<input type="checkbox"/> Deltaweld 452 Video Kit (#197 010) 324-1032 \$86.00
<input type="checkbox"/> S-64M Video Kit (#197 015) 324-1031 \$86.00	<input type="checkbox"/> Additional Deltaweld Test Sheet (#197 011) 324-1019 \$3.00
<input type="checkbox"/> Additional S-64M Test Sheet (#197 017) 324-1017 \$3.00	

Payment Information

☐ Check or Money Order Send check or money order payable to: Neenah Printing
Attn: Literature Distribution Center
P.O. Box 506
Neenah, WI 54957-0506

☐ Purchase Order _____ ☐ Mastercard ☐ Visa

Name of Card holder _____

Account # _____ Exp. Date _____

Cardholder's signature _____

To Order call 920-751-2120 or Fax 920-751-2121

Distributor Name _____ Customer # _____



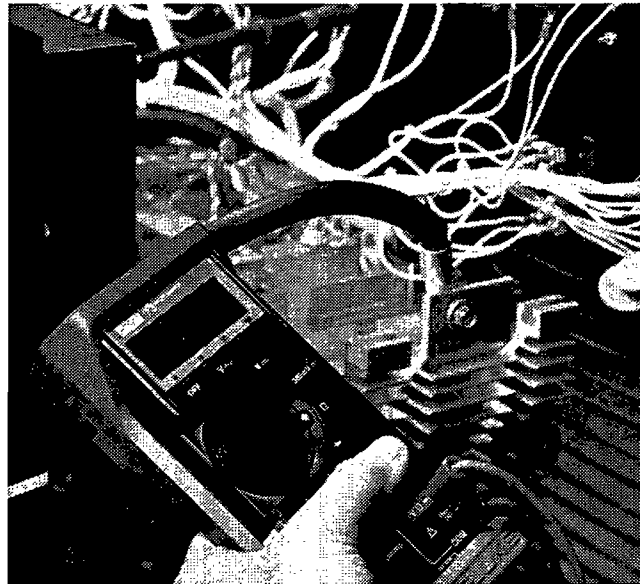
Miller®

WELDING EQUIPMENT SERVICE ENGINEERING

SELF-PACED TRAINING COURSE FROM MILLER ELECTRIC –

Learn the basics of welding equipment troubleshooting and servicing with this three module course designed for home study, industrial and educational use. This course will provide the basic knowledge to begin a career in servicing welding equipment, act as a refresher, or provide a welding salesman or technician service and troubleshooting techniques.

A certificate of completion is awarded by the Miller Training Department upon successful completion of the course.



SPECIFICATIONS

MODULE 1

Visual Inspection
High Frequency
Safety

MODULE 2

Volt-ohm Meter Operation
Load Bank Operation

MODULE 3

Electronic Symbols
Component Identification
Troubleshooting

ORDERING INFORMATION

☐ **Welding Equipment** (#145 870)
Service Engineering Training Course \$60.00
(Includes text, videotape, exams, and
registered answer card.)

☐ **Additional Text** (#145 871)
(Includes text and registered answer card.) \$35.00

Payment Information

☐ Check or Money Order Send check or money order payable to: Neenah Printing
Attn: Literature Distribution Center
P.O. Box 506
Neenah, WI 54957-0506

☐ Purchase Order _____ ☐ Mastercard ☐ Visa

Name of Card holder _____

Account # _____ Exp. Date _____

Cardholder's signature _____

To Order call 920-751-2120 or Fax 920-751-2121

Distributor Name _____ Customer # _____





TRUE BLUE®

WARRANTY

Effective January 1, 1999
(Equipment with a serial number preface of "KK" or newer)

Warranty Questions?

Call
1-800-4-A-MILLER
for your local
Miller distributor.

Your distributor also gives
you ...

Service

You always get the fast,
reliable response you
need. Most replacement
parts can be in your
hands in 24 hours.

Support

Need fast answers to the
tough welding questions?
Contact your distributor.
The expertise of the
distributor and Miller is
there to help you, every
step of the way.

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY - Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or one year after the equipment is sent to a North American distributor or eighteen months after the equipment is sent to an International distributor.

1. 5 Years Parts - 3 Years Labor
 - * Original main power rectifiers
 - * Inverters (input and output rectifiers only)
2. 3 Years — Parts and Labor
 - * Transformer/Rectifier Power Sources
 - * Plasma Arc Cutting Power Sources
 - * Semi-Automatic and Automatic Wire Feeders
 - * Inverter Power Supplies
 - * Intellitig
 - * Engine Driven Welding Generators
(NOTE: Engines are warranted separately by the engine manufacturer.)
3. 1 Year — Parts and Labor
 - * Motor Driven Guns (w/exception of Spoolmate 185)
 - * Process Controllers
 - * Positioners and Controllers
 - * Automatic Motion Devices
 - * Robots
 - * RFCS Foot Controls
 - * IHPS Power Sources
 - * Water Coolant Systems
 - * HF Units
 - * Grids
 - * Maxstar 140
 - * Spot Welders
 - * Load Banks
 - * SDX Transformers
 - * Miller Cyclomatic Equipment
 - * Running Gear/Trailers
 - * Plasma Cutting Torches (except APT, ZIPCUT & PLAZCUT Models)
 - * Field Options
(NOTE: Field options are covered under True Blue® for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
4. 6 Months — Batteries
5. 90 Days — Parts
 - * MIG Guns/TIG Torches

- * APT, ZIPCUT & PLAZCUT Model Plasma Cutting Torches
- * Remote Controls
- * Accessory Kits
- * Replacement Parts (No labor)
- * Spoolmate 185

Miller's True Blue® Limited Warranty shall not apply to:

1. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
2. Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

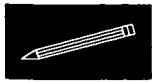
TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MILLER IS EXCLUDED AND DISCLAIMED BY MILLER.

Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.





Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



Resources Available

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:

To locate a distributor or service agency near you, call 1-800-4-A-Miller or visit our website at www.MillerWelds.com

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information and Parts)

Circuit Diagrams

Welding Process Handbooks

Contact the Delivering Carrier for:

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

File a claim for loss or damage during shipment.

Miller Electric Mfg. Co.

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters-USA

USA Phone: 920-735-4505 Auto-Attended
USA & Canada FAX: 920-735-4134
International FAX: 920-735-4125

European Headquarters - United Kingdom

Phone: 44 (0) 1204-593493
FAX: 44 (0) 1204-598066

www.MillerWelds.com

